

Date: Thursday, 2/23/2006 10:24:35 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STOP
 Job Number : 25932
 Estimate Number : 10513
 P.O. Number : N/A Part Number : D28052
 This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D2805 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 24620 Material : N/A
 Due Date : 3/22/2006 Qty: 20 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06-02-23
 Comment : Est: B 0041.14 Revised Finishing step to Acid etch and Alodine EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1500X01500 6061-T6 Bar 1.5" x 1.5"



Comment: Qty.: 0.2756 f(s)/Unit Total: 5.5125 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: M16954 ml 06/02/22 20

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

ml 06/02/22 20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-2

ml 06/02/01 20 PTO

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/01 20

5.0 QC8 SECOND CHECK









Comment: SECOND CHECK

ML 06/03/00 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/03/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/01	3	1 piece scrap, the drill broke inside the piece 1 piece scrap scrap, the piece pop outside	 	destroy and replace <u>2 parts</u>	 06/03/01	 06-03-01		 06-03-01

NOTE: Date & initial all entries

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Drawing Name: STOP

Job Number: 25932

Part Number: D28052

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06:03:08

20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

06:03:07

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57387

AC 6/3/8 20

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06:03:08

Job Completion



u 06:03:08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

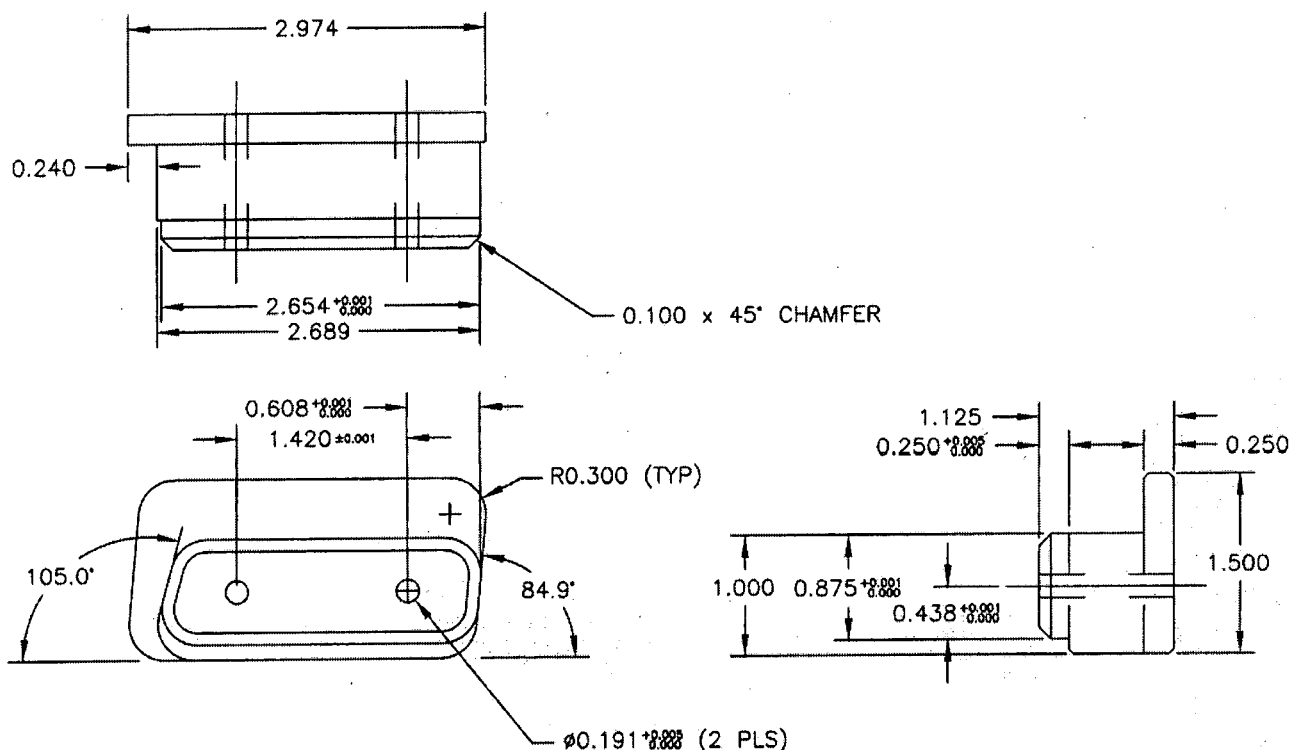
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
 BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
 MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 25932

WORK ORDER
NO. 25932

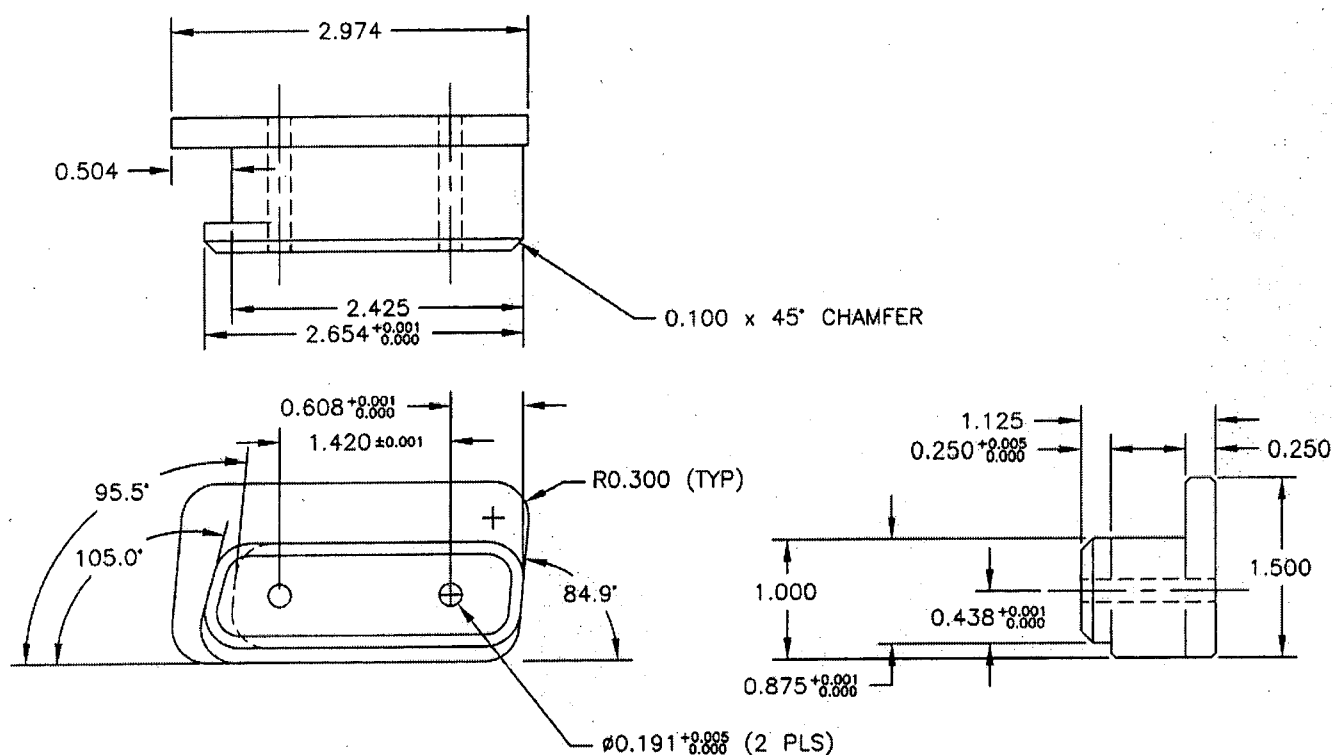
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

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